

**Work Order ID 80109**

February 10, 2012 8:13:43 AM

**\*80109\***

Page 1

Item ID: D6202

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: I-Beam Extrusion

Stop **\*NS2\***

Start Date: 2/10/12 Start Qty: 40.00

~~\*40\*~~

Cust Item ID:

Required Date: 2/15/12 Req'd Qty: 40.00

~~\*40\*~~

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D6202

Rev A

100

0.00

**\*100\***

Purchasing

PURCHASING

Memo

16443.00

Purchasing

Issue P/O: ~~11105~~ a) Description: American standard I-beam 4.000"  
x 2.796" x 0.326" thick b) Material: 6061-T6/T651 (QQ-A-200/8) c)  
Minimum ultimate tensile strength = 38 ksi d) Minimum yield tensile strength  
= 35 ksi

CD 12/03/13 50ft

110

Receive &amp; Inspect for Damage &amp; Mat'l Certs

0.00

**\*110\***

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

CD 12/03/21 50

120

QC6- Inspect dimensions to drawing

0.00

**\*120\***

QC

Memo

0.00

Quality Control

Ensure Material certification comply to Dwg D6202

CD 12/03/23

50

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 80109

**\*80109\***

Page 2

February 10, 2012 8:13:43 AM

Item ID: D6202

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: I-Beam Extrusion

Start Date: 2/10/12 Start Qty: 40.00

**\*40\***

Cust Item ID:

Required Date: 2/15/12 Req'd Qty: 40.00

**\*40\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>MAT28</i>	0.00							
<b>*130*</b>									
Packaging	Memo	0.00				<i>50</i>	<i>10</i>		
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

*ant 12/03/23*

*MLJ 12/03/26*

*ME 12-03-24*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

February 10, 2012 8:13:43 AM

Page 1

Work Order ID: 80109

Parent Item: D6202

Parent Item Name: I-Beam Extrusion

Start Date: 2/10/12

Required Date: 2/15/12

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A: 01.04.19New Issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6202P I Beam Extrusion		Purchased	No			110	f	0.0000	1	40		2/23/12	SC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

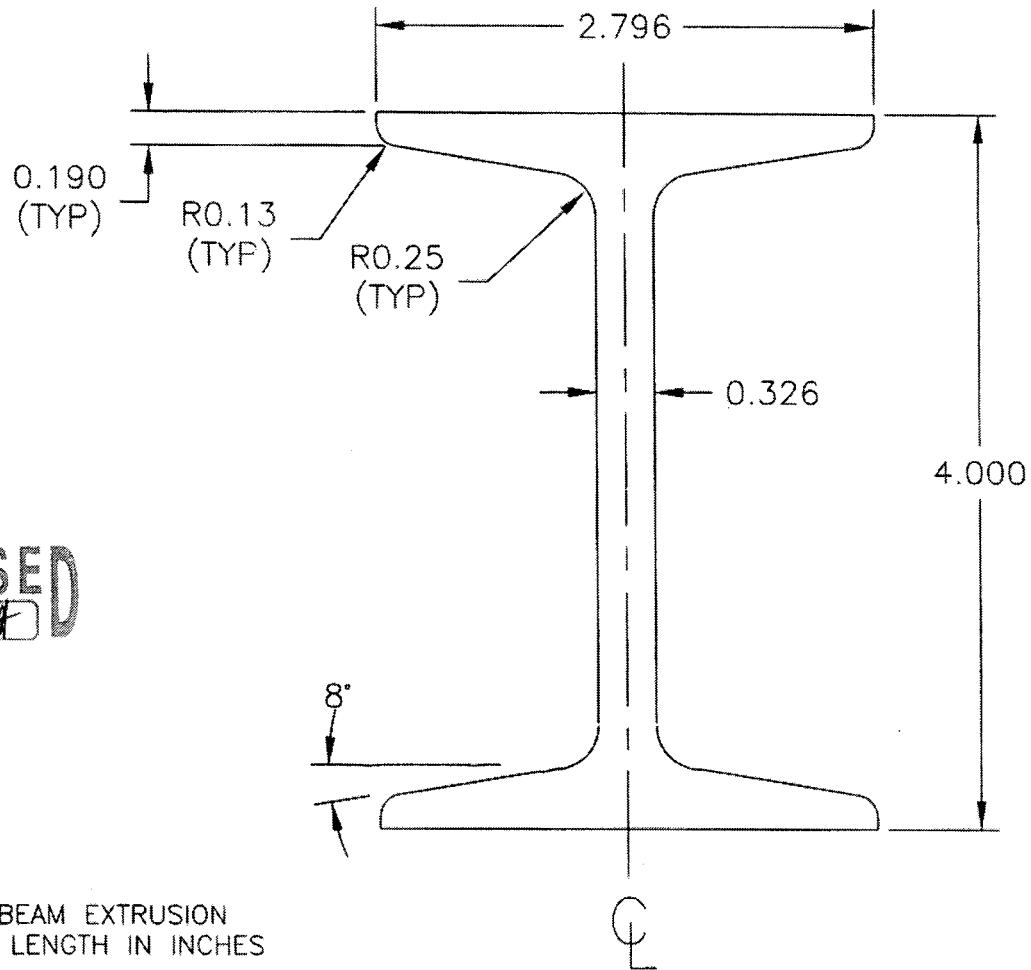
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6202	REV. A SHEET 1 OF 1
DATE 01.04.02		TITLE I-BEAM EXTRUSION	SCALE 1:1
A	01.04.02	NEW ISSUE	

## SPECIFICATION CONTROL DRAWING

01.04.02  
01.04.02  
01.04.02



D6202-XXX I-BEAM EXTRUSION  
WHERE XXX IS LENGTH IN INCHES

EG.  
D6202-027 IS 27 INCHES LONG

PURCHASE MATERIAL: AMERICAN STD. I-BEAM  
4.000" x 2.796" x 0.326" THICK  
6061-T6/T651 (QQ-A-200/8)  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO16443

Purchase Order Date 3/14/12

PO Print Date 3/14/12

Page Number 1 of 1

Order From :

VC-MAG002

MAGNA STAINLESS  
5775 RUE KIERAN  
ST LAURENT, QC H4S 0A3  
CA

Contact Name

Buyer

Chantal Lavoie

Vendor Phone

800 363 6646

Requisition Nbr

Vendor Fax

514 339 1105

Tax Resale Nbr

10127-2607

Vendor Account Nbr

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

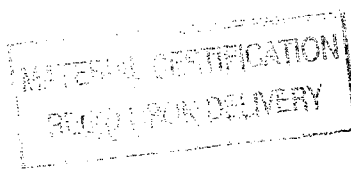
**FAXED**  
3/14/12

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D6202P	1 Beam Extrusion	3/28/12 Yes	50.00 f	Yours ppd	\$22.3600	\$1,118.00

Special Inst: AS PER DWG D6202 REV. A  
B80109  
MATERIAL: 6061-T6 AS PER QQ-A-200/8  
SIZE: 4.000" X 2.796" X 0.326" THICK  
MINIMUM ULTIMATE TENSILE  
STRENGTH = 38 KSI  
MINIMUM YIELD TENSILE STRENGTH  
= 35 KSI

PO Total:

\$1,118.00



Change Nbr: 1

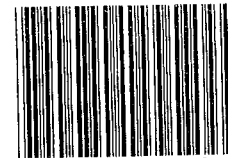
Change Date: 3/14/12

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable



# Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3  
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105



\*1056842\*

## PACKING LIST

Page 1 of 1

I056842

SOLD TO:  
DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY, ON K6A 1K7

SHIP TO:  
DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY, ON K6A 1K7

SPECIAL INSTRUCTIONS

Contact: CAROLE

Ship Terms: PREPAID

MTR:C

Contact: CAROLE

Ship Terms: PREPAID

Currency		Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS		CHRISTINA ANTONIOU	(613) 632-5200	(613) 632-1053	P016443	
Sales Order	Terms	Ship Via		Date Ordered	Date Required	Date Shipped
W062873	NET 30 DAYS	NIR:R-557065-1		03/14/12	03/22/12	03/22/12

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
2		PC	AIRCRAFT - PCS ALUM I BEAM 4" X 2.80" X .326 X 25' LG SPEC REQUIRED QQA 200/8 MILL TEST + C OF C REQUIRED WITH DELIVERY PER QQA 200/8 REF D6202	L060485	201118211	2 2
Bundles: 1				Approx Weight:		169 LB

Received by: \_\_\_\_\_ Date: \_\_\_\_\_ Signature: \_\_\_\_\_

P18321

C05452



SERVICE CENTER METALS  
5850 Quality Way  
Prince George, VA 23875

# CERTIFIED INSPECTION REPORT AND TEST RESULTS FOR EXTRUDED PRODUCTS

OUR ORDER NUMBER	ITEM
137562	13

MANIFEST NUMBER 145491  
DIE NUMBER BS0291  
DATE OF SHIPMENT 11/23/2011  
CUSTOMER PO P10926DS007 CT  
ALLOY/TEMPER 6061-T6  
SALESPERSON David Schroeder  
CUSTOMER PART NUMBER BS0291  
DESCRIPTION ASI 4.000x2.796x.326

CERTIFICATION  
ASTM-B308-10 SPOT STENCIL  
SPECIFICATION  
ASTM-B221-08  
SPECIFICATION  
AMS-QQA-200/8  
SPECIFICATION  
AMS-QQA-200/16

Quantity Certified 1,561 lbs 19 pcs

We hereby certify that the material covered by this report has been inspected in accordance with the most recent certification revision, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description, and that samples representative of the material met the composition limits and had the mechanical properties shown. SCM extrusions are manufactured in the USA from ingot melted and cast in the United States or Canada.

Mechanical Properties		Test Date	Ultimate Tensile Strength (KSI)	Yield Strength (KSI)	Percent Elongation
Tests	Lot No.				
1	201118211	11/20/11	42.5	39.8	14.4

## Chemical Composition for Aluminum Alloy 6061

Cast Number	Alloy	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Others Each	Total	Melted In United States of America
C67R0006	6061	0.62	0.19	0.18	0.01	0.84	0.06	0.01	0.01	0.05	0.15	

*Calvin J. Wiggins*

Print Date: 11/23/2011

Calvin J. Wiggins, Director of Quality & Technical Services

Rev. 9/23/11 - UMS

**MAGNA INOXYDABLE  
INC.**

5775 RUE KIERAN  
ST-LAURENT, QUEBEC  
H4S 0A3 (514) 339-1211, 1-800-363-6646

**CERTIFICAT DE CONFORMITE**  
**CERTIFICATE OF CONFORMANCE**

**DATE:** March 21, 2012

**COMPAGNIE / DART AEROSPACE LTD**  
**COMPANY:**  
**ATTENTION:**

**VOTRE/YOUR #:** P016443

**DATE DE LA COMMANDE / 03/14/12**  
**ORDER DATE:**

**NOTRE / OUR #:** I056842

<u>DESCRIPTION</u>		<u>QUANTITE/QUANTITY</u>	<u>SPECIFICATIONS</u>
<b>TYPE:</b>	6061-T6 ALUM I BEAM	2 PC	AMS QQA 200/8
<b>SIZE:</b>	4" X 2.80" X .326 X 25' LG		
<b>HEAT #:</b>	201118211		

**MILL SOURCE: SERVICE CENTER METALS**

Magna Stainless certifie que le matériel décrit ci-dessus, s'accorde aux dessins ou aux spécifications demandées sur le bon de commande et qui sont en vigueur à la date ou la commande est acceptée.  
Magna Stainless certifies that the material described above is in accordance with the drawing or specifications called for on said order that is current on the date order was accepted.

**MAGNA**  
**MTR #: L060485**

Signed: 